

Work Order ID 63464

November 2, 2010 12:56:32 PM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 10/11/02 Tooling:

Date:

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2445/D350-588	Rev D/D								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

S 10/12/07

HJ 6/ BG 11-01-26 (1)

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12854
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

CZ 10/11/03 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63464

November 2, 2010 12:56:32 PM



Page 2

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120



Packaging

Receive & Insp for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

11/10/27 (1)

130



QC

Quality Control

QC6- Inspect dimensions to drawing

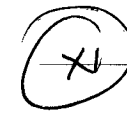
0.00

Memo

0.00

Inspect as per Dwg D2445.
Audit process sheet.

Sillab5



140



Small Fab

Small Fab

0.00

Memo

0.00

Assemble all of the above parts as per Dwg D350-588

85 11 01 26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63464

November 2, 2010 12:56:32 PM



Page 3

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
155 Packaging Packaging	Pick Kit Memo	0.00 0.00							
160 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63464

November 2, 2010 12:56:32 PM



Page 4

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: 43

0.00

Memo

Revd

0.00

11/1/27

S

(K)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/01/27

W 11/06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 2, 2010 12:56:31 PM

Page 1

Work Order ID: 63464

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly



Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04 Reformat KJ/DS IPP Rev:Q as
per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD
10.03.29 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2445P 		Purchased	No			110	Each	0.0000	1	1			
AFT DOOR ASSEMBLY													
AN526C832R9 		Purchased	No			140	Each	149.0000	8	8			
Screw													

Location	Loc Qty	Loc Code
ST327	149	
115422	3	
115835	46	
115936	100	

AN960JD10 	NAS1149D0363J	Purchased	No			140	Each	8.0000	2	2			
Washer													

Location	Loc Qty	Loc Code
ST	6	
107715	6	
ST335	2	
105792	2	

AN960JD8 	NAS1149DN832J	Purchased	No			140	Each	10.0000	8	8			
Washer													

Location	Loc Qty	Loc Code
ST347	10	
105059	10	

B63464 ST 11-01-26

ST 11-01-26

ST 11-01-26

ST 11-01-26

M116419

M116025

M116513

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

November 2, 2010 12:56:31 PM

Work Order ID: 63464

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2143 Manufactured No 140 Each 10.0000 1 1
Hinge Bracket

B64308



ET 11-01-26

Location Loc Qty Loc Code

ST198 10
55323 10

D2144 Manufactured No 140 Each 35.0000 1 1
Hinge Bracket

Location Loc Qty Loc Code

ST198 35
55179 35



ET 11-01-26

D2463 Manufactured No 140 f 486.1100 7.25 7.25
Seal

B64944



ET 11-01-26

Location Loc Qty Loc Code

ST404 486.11
55561 1.68
62597 484.43

(D2463-0870) cut (1) at 87.00"
**** per kit****

D2585 Manufactured No 140 Each 50.0000 2 2
Mounting Channel

B64655



ET 11-01-26

Location Loc Qty Loc Code

ST018 33
62676 33
ST019 17
59873 17

November 2, 2010 12:56:31 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 2, 2010 12:56:31 PM

Work Order ID: 63464

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10


Start Qty: 1.00

Required Qty: 1.00

D2586 Manufactured No 140 Each 52.0000 2 2

 Door Latch


B64656

 ST 11-01-26

Location	Loc Qty	Loc Code
ST204	52	
61655	52	

D2621 Manufactured No 140 Each 67.0000 2 2

 Latch Plate, 350 Spacepod

 ST 11-01-26


Location	Loc Qty	Loc Code
ST021	67	
46842	7	
56526	60	

x2

D2857-1 Manufactured No 140 Each 28.0000 1 1

 Hinge Bracket

B64435

 ST 11-01-26

Location	Loc Qty	Loc Code
ST026	28	
56529	5	
57924	23	

D2857-2 Manufactured No 140 Each 32.0000 1 1

 Hinge Bracket

 ST 11-01-26

Location	Loc Qty	Loc Code
ST027	32	
55020	1	
56530	7	
57925	24	

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 2, 2010 12:56:31 PM

Work Order ID: 63464

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

160.0000

8

8



Nut

M116549



RT 11-01-26

Location

Loc Qty

Loc Code

ST300

160

115835

160

MS21042L3

Purchased

No

140

Each

1,898.000

4

2



Nut



RT 11-01-26

Location

Loc Qty

Loc Code

ST300

1898

114784

898

115835

1000

x2

MS27039-1-15

Purchased

No

140

Each

47.0000

2

2



Screw



RT 11-01-26

M116189

Location

Loc Qty

Loc Code

ST292

47

114056

2

114718

45

AN526C1032R7

Purchased

No

155

Each

46.0000

2

2



Screw



M116301 11/1/26

Location

Loc Qty

Loc Code

ST328

46

113064

1

113749

1

114056

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

November 2, 2010 12:56:31 PM

Work Order ID: 63464

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

AN526C832R8

Purchased

No

155

Each

132.0000



Screw

8 18 32
M116410

M116471

11/12/10

Location

Loc Qty

Loc Code

ST327

132

114615

32

114718

100

AN960JD10

NAS1149D0363J

Purchased

No

155

Each

8.0000



Washer

2 1 2
M116025

11/12/10

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD8

NAS1149DN832

Purchased

No

155

Each

10.0000



Washer

16
M116513

11/12/10

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2150

Manufactured

No

155

Each

20.0000



Packer Doubler, Hinge

2 2
M11664764

11/12/10

Location

Loc Qty

Loc Code

ST007

20

55178

20

November 2, 2010 12:56:31 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 2, 2010 12:56:31 PM

Work Order ID: 63464



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2151
Packer Doubler, Hinge

Manufactured No

155 Each

43.0000

2 2



11/1/26 B64310 SD

Location

Loc Qty

Loc Code

ST007

43

55319

5

62246

38

D2153
Door Prop

Manufactured No

155 Each

16.0000

1 1



B64311 11/1/26 SD

Location

Loc Qty

Loc Code

ST272

16

59818

16

D2154
Stud Bracket

Manufactured No

155 Each

6.0000

1 1



11/1/26 B64312 SD

Location

Loc Qty

Loc Code

ST007

6

55325

3

62479

3

D2237
Striker Plate

Manufactured No

155 Each

52.0000

2 2



11/1/26 B64426 SD

Location

Loc Qty

Loc Code

ST009

5

60492

5

ST010

47

62212

47

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

November 2, 2010 12:56:31 PM

Work Order ID: 63464

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2461 Manufactured No

155 f

115.7072 7.25 7.25



Neoprene "D" Seal



11/1/26 B63880 SD

Location

Loc Qty

Loc Code

ST402

115.7072105

39782

6.5

55054

109.207211

(D2461-0870) cut (1) at 87.00"

**** per kit****

D2589

Manufactured No

155 Each

161.0000



Keys, Key Chain, 350 Hinge



11/1/26

Location

Loc Qty

Loc Code

ST019

161

58194

161

155 Each

16.0000

D2690-17

Manufactured No



Cable



11/1/26 B64786 SD

Location

Loc Qty

Loc Code

ST021

16

62480

16

155 Each

15.0000

D2858-1

Manufactured No



Hinge Bracket



11/1/26 B63695 SD

Location

Loc Qty

Loc Code

ST027

15

56423

9

61522

6

November 2, 2010 12:56:31 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 2, 2010 12:56:31 PM

Work Order ID: 63464

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2858-2
Hinge Bracket

Manufactured No

155 Each

7.0000

11/1/20 B64987 SP

Location	Loc Qty	Loc Code
ST027	7	
56048	1	
61523	6	

FG-778150-550-ROL
7781 9oz Glass 50"x125yd

Purchased No

155 sf

1,840.750

11/1/20 SP

Location	Loc Qty	Loc Code
ST404	1840.75	
108932	18	
111166	397	
113905	1425.75	

CUT ONE SQUARE FEET PER KIT
MS20426AD3-4
RIVET

Purchased No

155 Each

5,984.000

11/1/20 SP

Location	Loc Qty	Loc Code
ST316	5984	
104374	1984	
110398	4000	

MS20470AD4-5
Rivet, Universal Head

Purchased No

155 Each

526.0000

11/1/20 M116410 SP

Location	Loc Qty	Loc Code
ST309	461	
114761	461	
ST319	65	
111916	65	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 2, 2010 12:56:31 PM

Work Order ID: 63464



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

155

Each

160.0000



Nut



M116549

11/12/10

Location

Loc Qty

Loc Code

ST300

160

115835

160

MS21042L3

Purchased

No

155

Each

1,898.000



Nut



11/12/10

sf

Location

Loc Qty

Loc Code

ST300

1898

114784

898

115835

1000

MS27039-08-11

Purchased

No

155

Each

45.0000



Screw



M116289

11/12/10

Location

Loc Qty

Loc Code

ST288

45

114382

45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

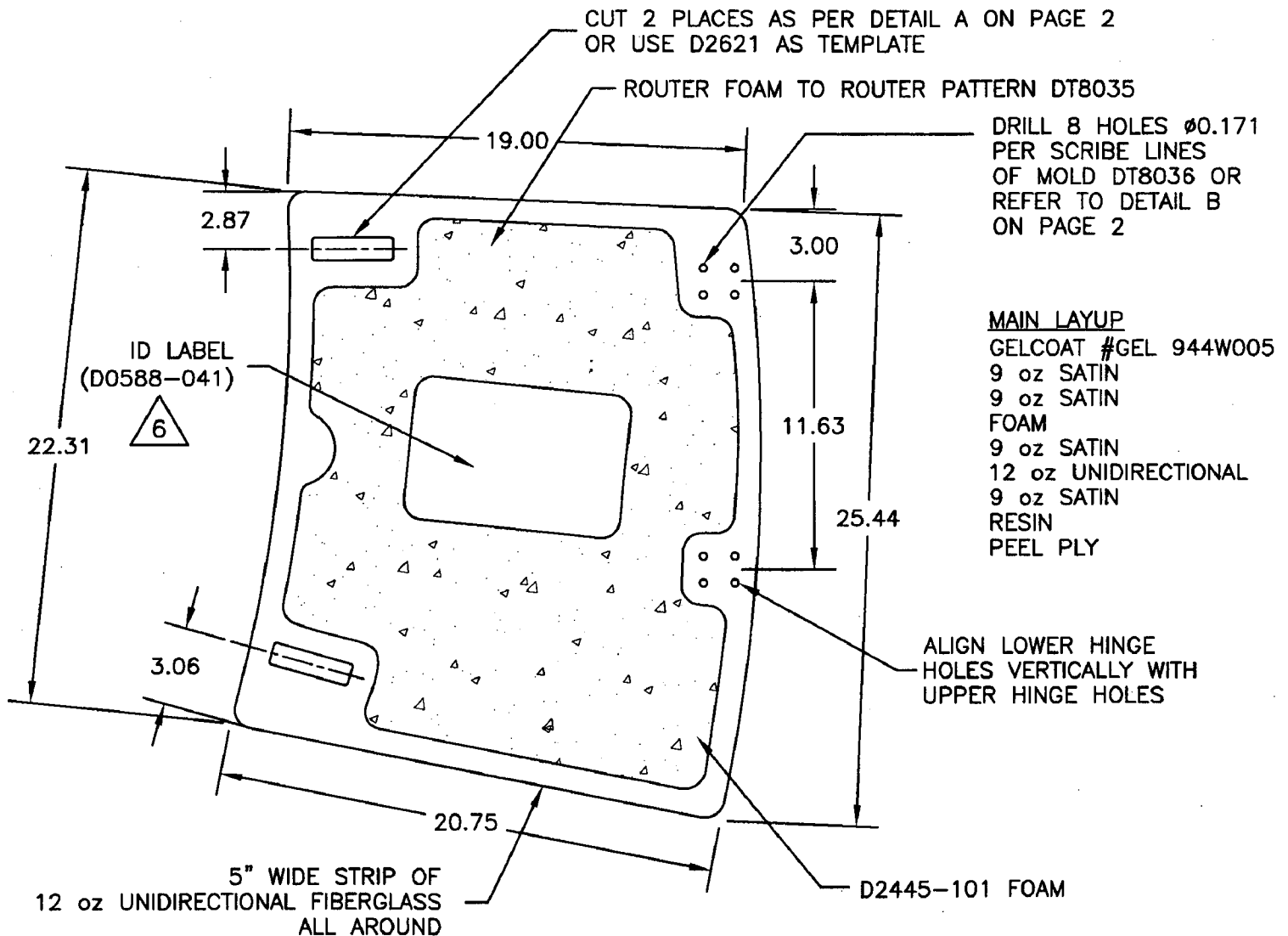
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED06.11.13 *[Signature]***NOTES:**

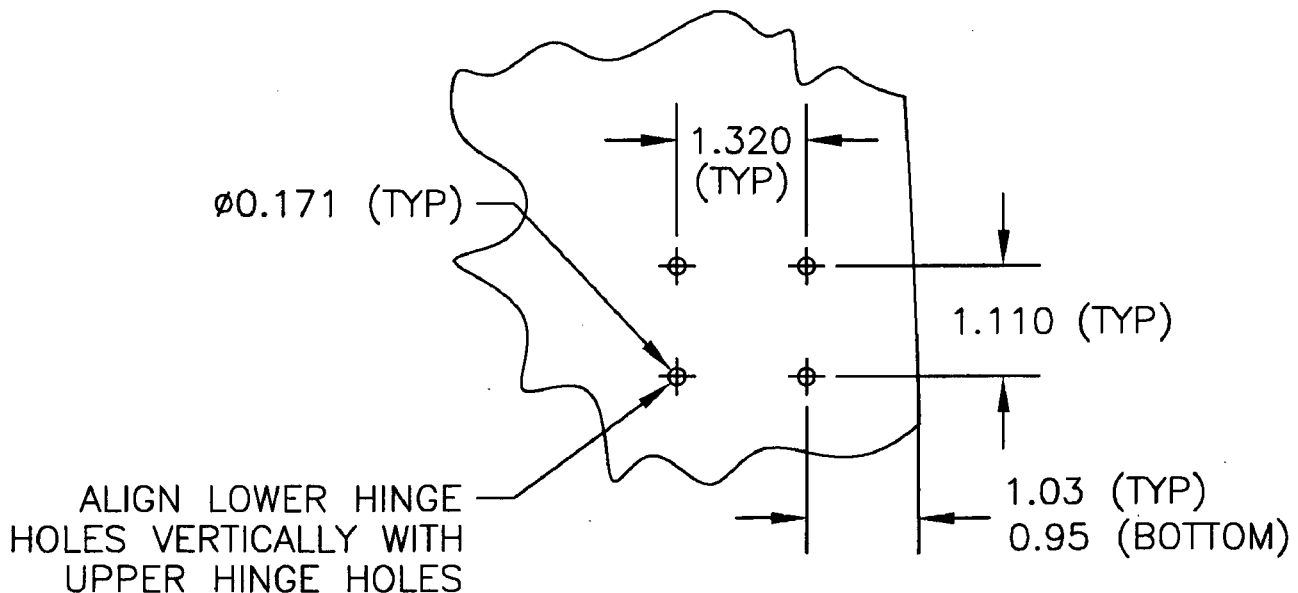
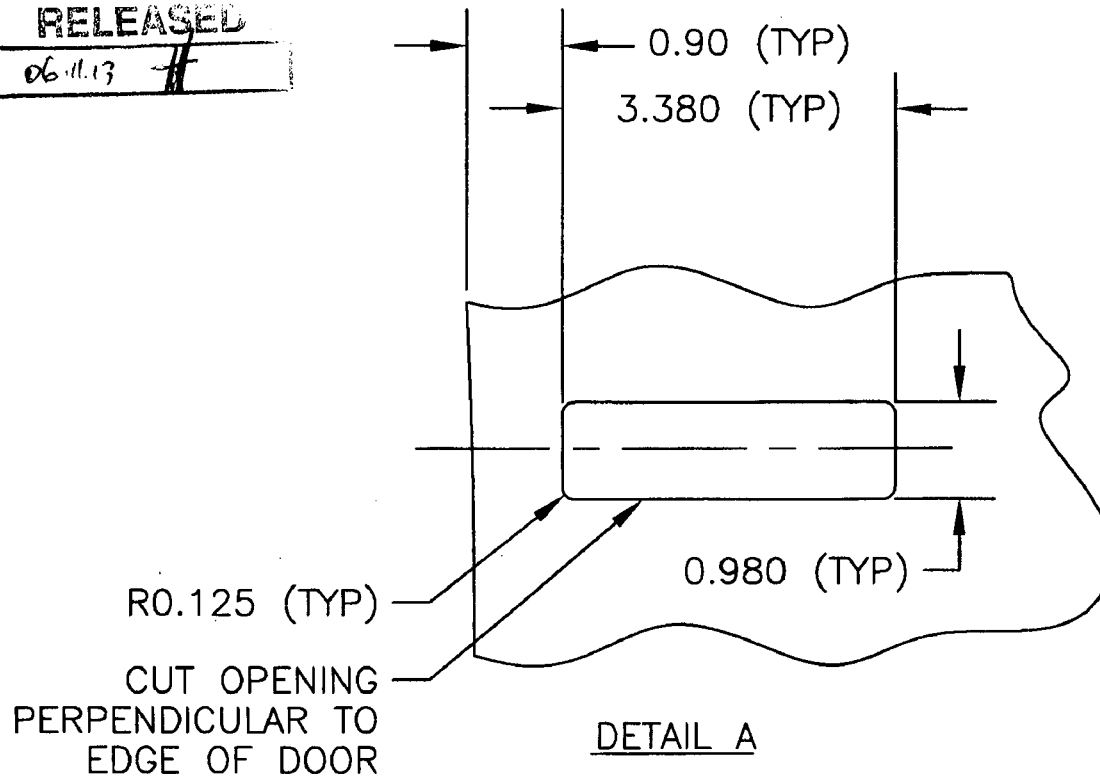
- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DMVYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

C 210/11/02
*W 10.6340***Copyright © 1997 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED06.11.13 *[Signature]*DETAIL B w10:63464**Copyright © 1997 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

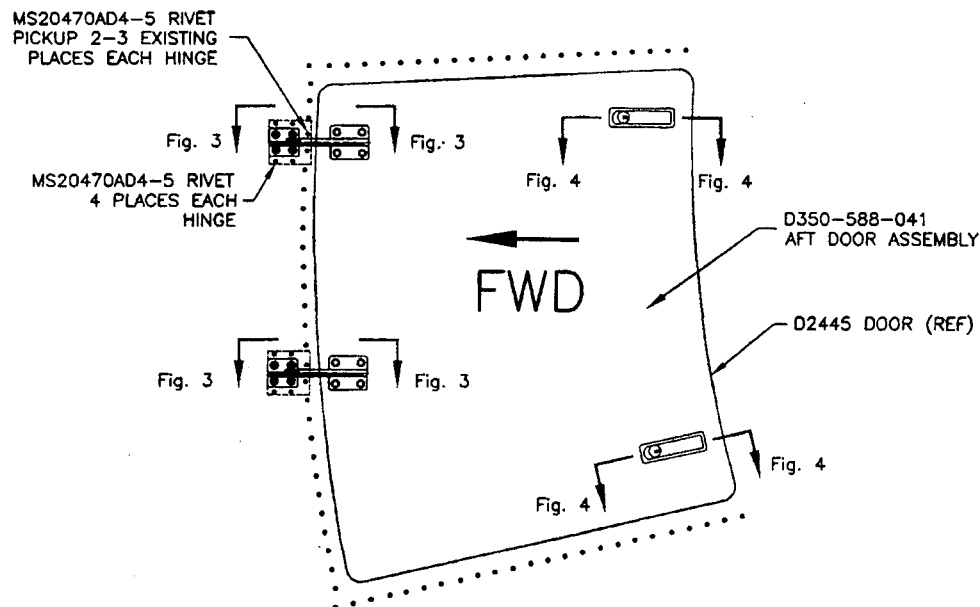
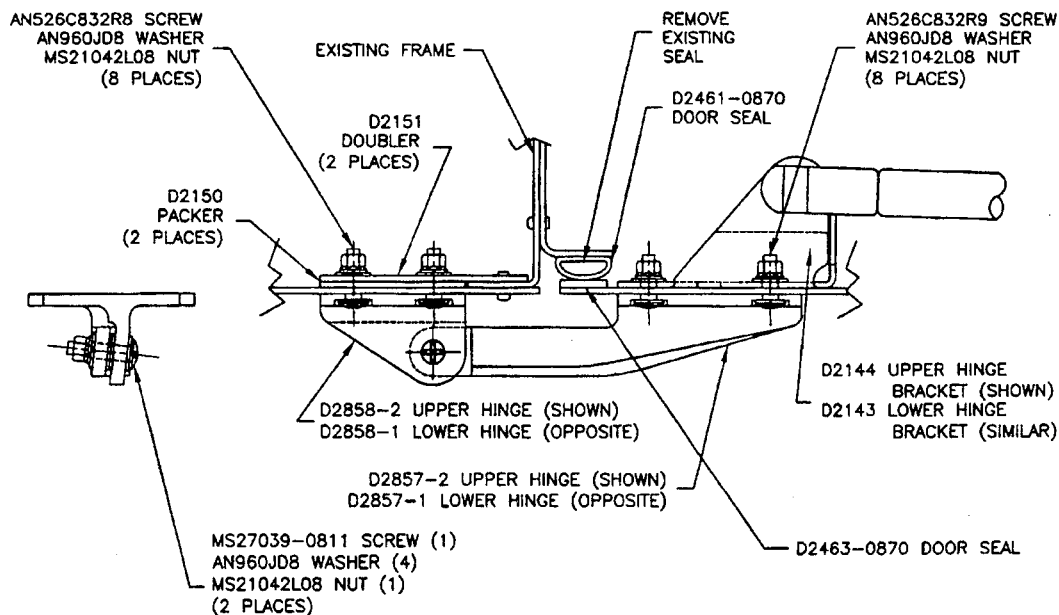


Figure 2: Baggage Door Outside View



W10.63464

Figure 3: Hinge Detail

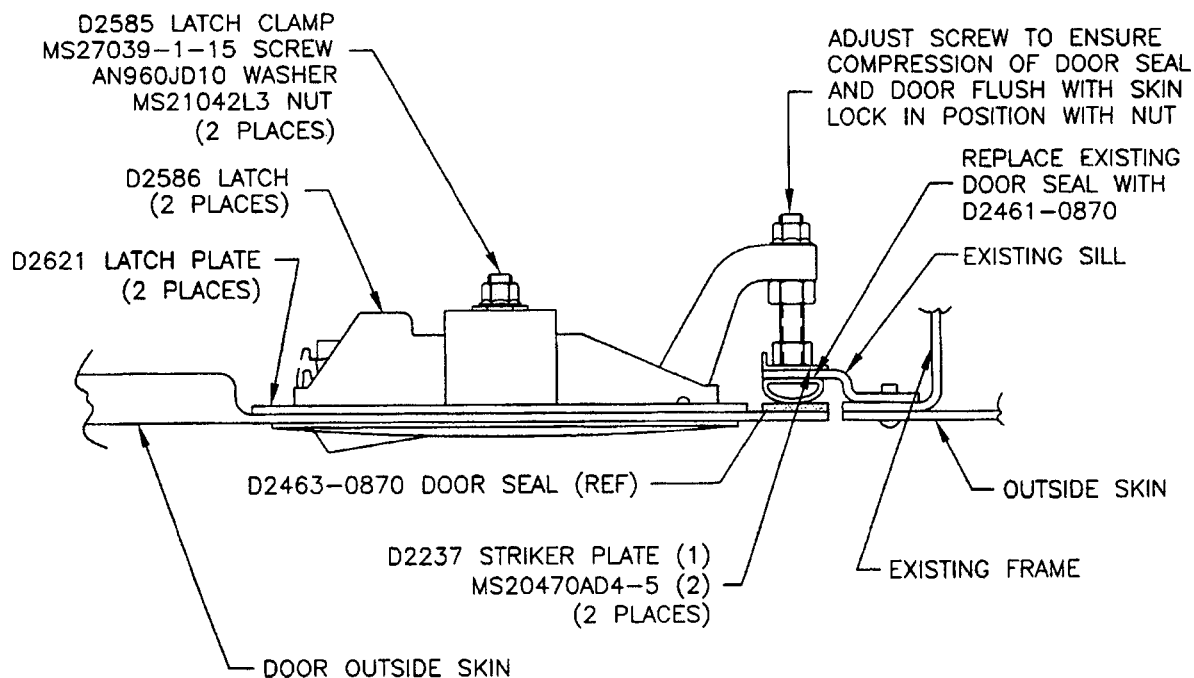
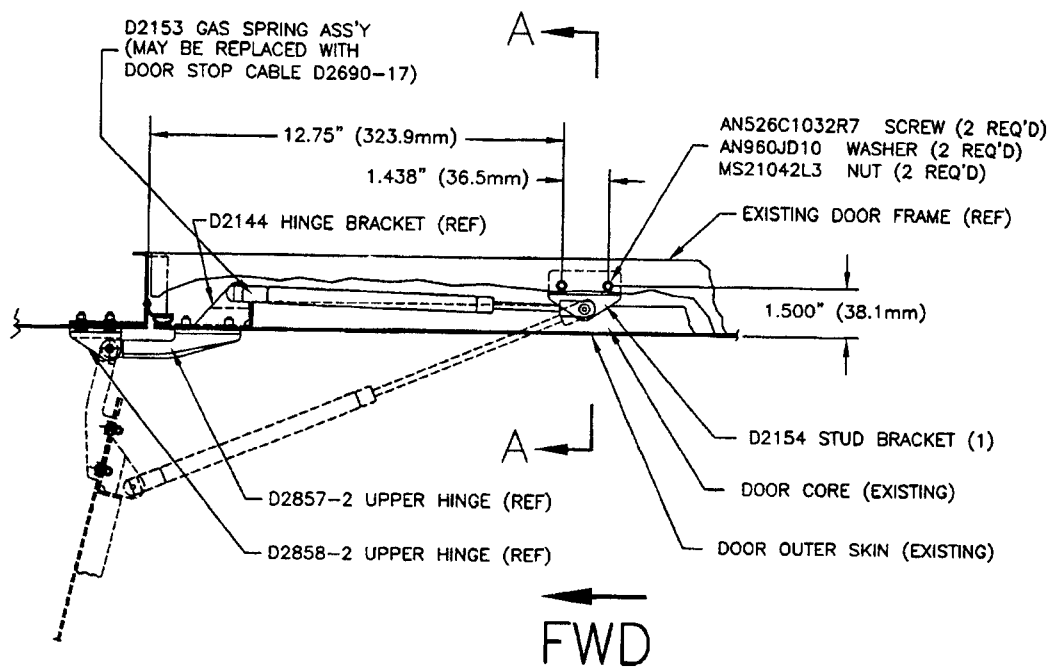


Figure 4: Latch Section

W10: 63464



SECTION A-A

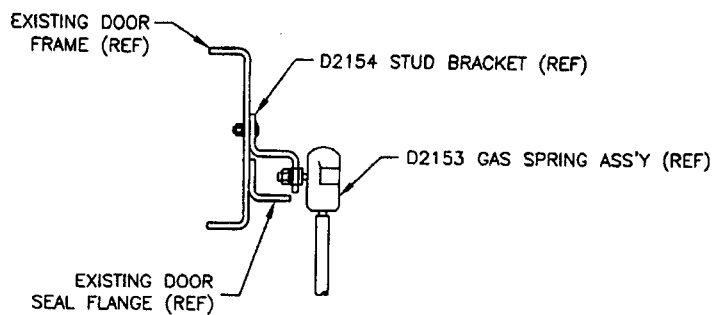


Figure 5: Gas Spring Installation

W101 63469

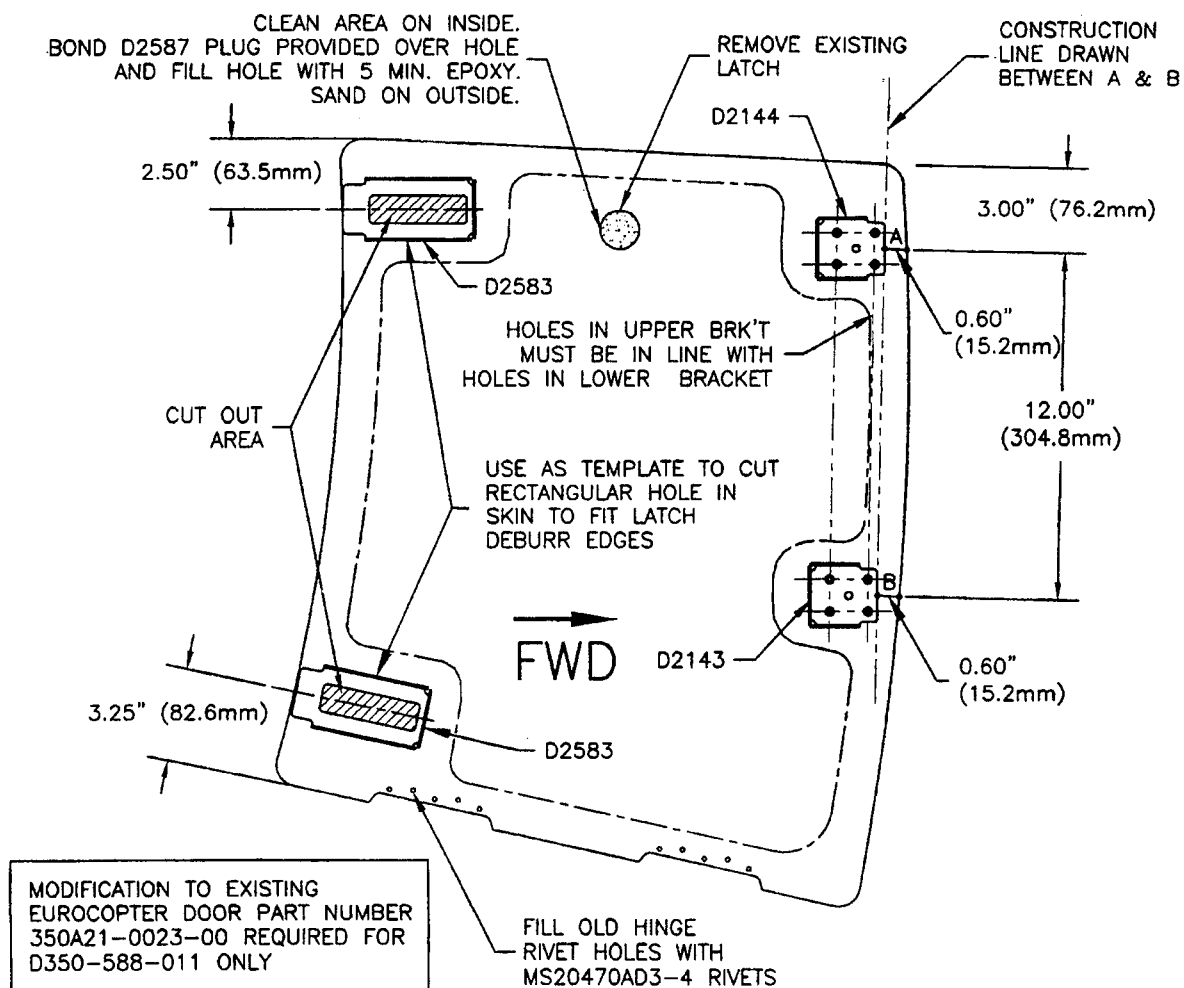


Figure 6: Baggage Door Inside View

W10.63469

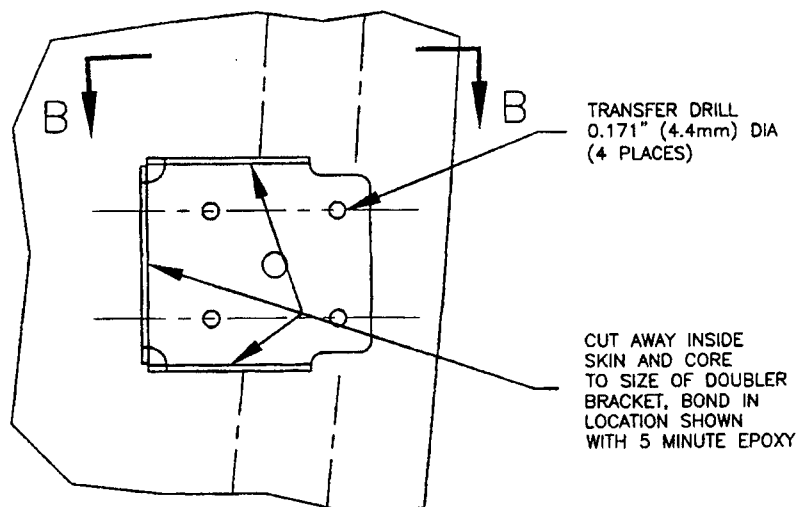
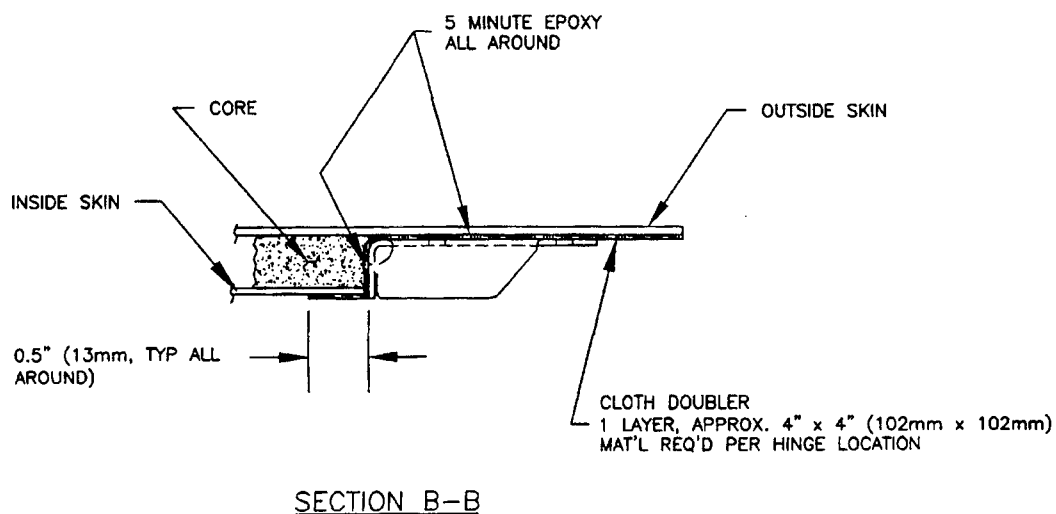


Figure 7: Typical Doubler Bracket Installation

10. 63465

3.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011 Aft Door Fwd Hinge Modification Kit	1.0 lb 0.45 Kg	-21.0 in -0.53 m	-21.0 in-lb -0.24 m-Kg	+170.0 in +4.32 m	+170.0 in-lb +1.96 m-Kg
D350-588-041* Aft Door Assembly	2.0 lb 0.91 Kg	-21.0 in -0.53 m	-42.0 in-lb -0.48 m-Kg	+170.0 in +4.32 m	+340.0 in-lb +3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

W10.6 3469

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
		D2143	HINGE DOUBLER
		D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
		D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
		D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

52-00-00

REFERENCE

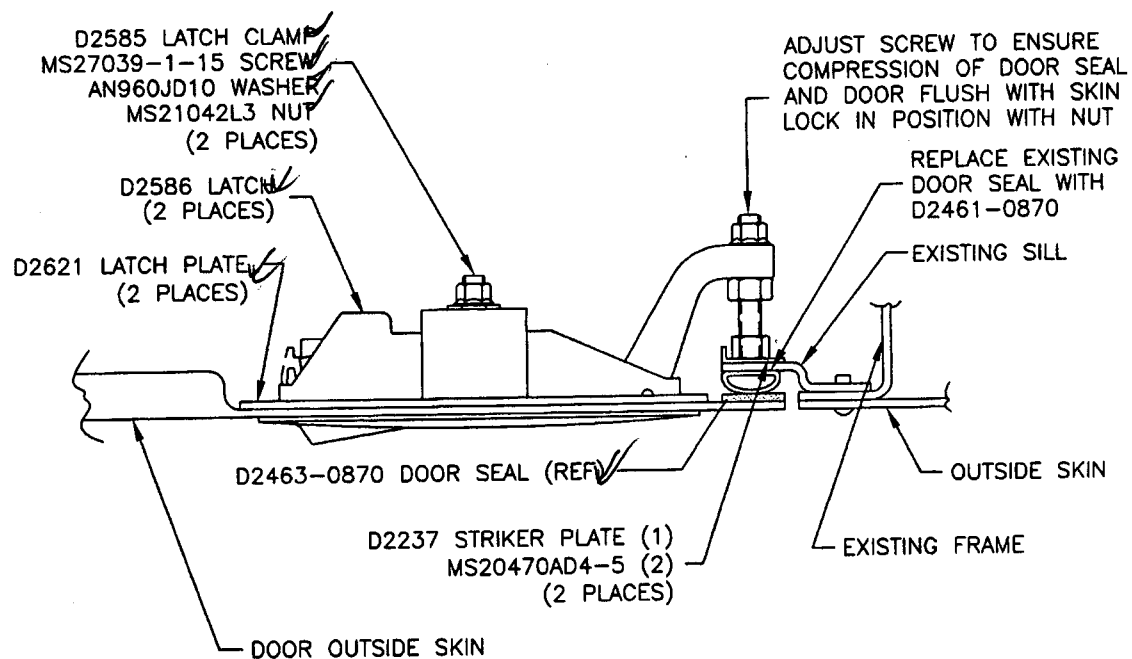


Figure 52-3: Latch Section

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

REFERENCE ONLY

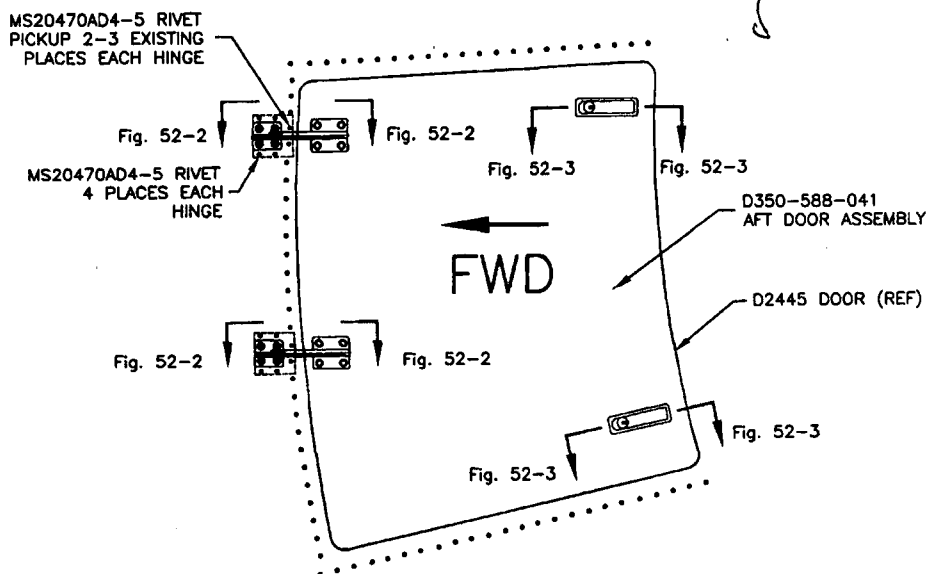


Figure 52-1: Baggage Door Outside View

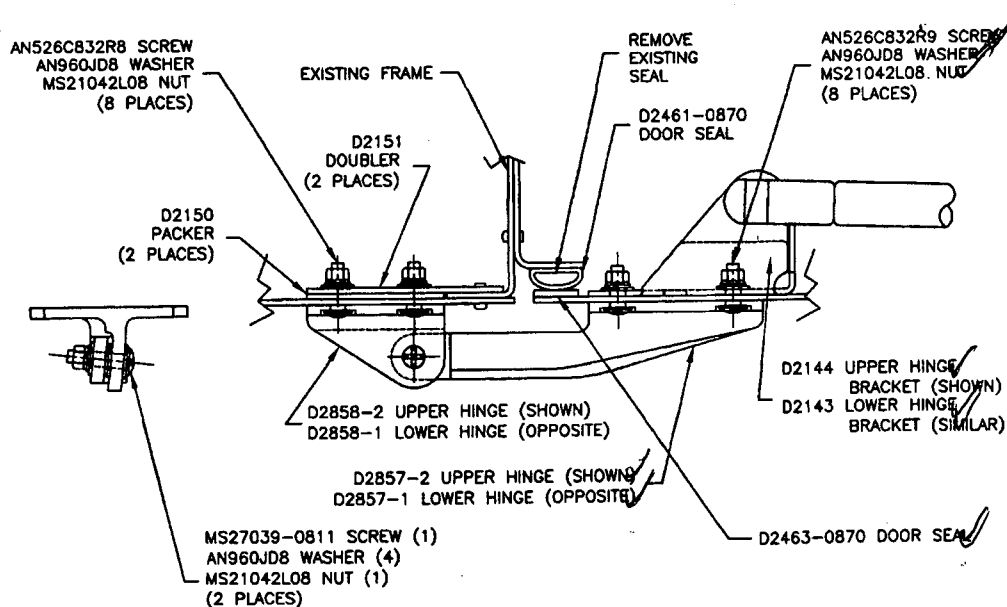


Figure 52-2: Hinge Detail

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	36761
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson					
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233					
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #					
20/01/2011	03/11/2010	15934	Chantal Lavoie		PO12854						
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description							
1	0	1	DKC134-0013	D350-588-041 Aft Baggage Door (D2445) B63464 U de M : Each							
				Drawing N° : D2445 Rév.: D							
				<table><tr><td><u>No. série</u></td><td><u>No. lot</u></td></tr><tr><td>B63464</td><td>30445</td></tr></table>				<u>No. série</u>	<u>No. lot</u>	B63464	30445
<u>No. série</u>	<u>No. lot</u>										
B63464	30445										
			<i>Sulob25</i>								

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by: 

Quality department

AQ-357



Date: Mercredi, 2010-11-24 10:59:55
Utilisateur: Pascal Carignan

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
Numéro Job : 30445
Numéro Soumission : 3959
Numéro B.A. :
Cette fois : 2010-11-24 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 30103

Nom Dessin : N° D2445, AFT BAGGAGE DOOR
Numéro Article : DKC134-0013
Numéro Dessin : D2445
Projet Numéro : DKC134
Révision dessin : D
Matériel : Composite
Date Dûe : 2010-12-01 Qté: 1 Udm: UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: D2445



B63464

Process Sheet Rév.: 00 Création du premier dans DKA à partir de la
Rév.: 10 de DKC

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0085	FREKOTE 3,78L 44-NC

Commentair Qty.: 0.20 UNITE(s)/Unit Total : 0.20 UNITE(s)

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-29020-

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

5.0	AC0747	Acetone
-----	--------	---------

Commentair Qty.: 0.130 KILOGRAMME(s)/Unit Total : 0.130 KILOGRAMME(s)

6.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 30-11-10 Sceau:  Temps Début: _____ Temps Fin: _____

Date: Mercredi, 2010-11-24 10:59:56
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30445

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

7.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IG 0019

Date: 30-11-10 Sceau:  Temps Début: — Temps Fin: —

8.0	AC0883	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)

9.0	AC0884	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)

10.0	AC0885	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

11.0	AC0943	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

12.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-28776-2

13.0	AMB0349	Fiberglass 12 oz Unidirectional
------	---------	---------------------------------

Commentair Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

14.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentair Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

15.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: Mercredi, 2010-11-24 10:59:56

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 30445

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: 24 nov 10 Heure Début: _____ Heure Fin: _____ Sceau:

16.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0130 GALLON(s)/Unit Total : 0.0130 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

17.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-29179-1

18.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 30-11-10 Heure Début: _____ Heure Fin: _____ Sceau:

19.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 30-11-10 Heure Début: _____ Heure Fin: _____ Sceau:

20.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date: 30-11-10 Heure Début: _____ Heure Fin: _____ Sceau:

Curing début: 1:15 Curing Fin: 8:00

Date: Mercredi, 2010-11-24 10:59:56

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 30445

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

21.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

22.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-29179-1

23.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préapration de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 2-12-10 Heure Début: _____ Heure Fin: _____ Sceau: _____



24.0	AAC1611	Polybond B46F
------	---------	---------------

Commentair Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s)
Polybond B46F N° de Lot: 1-26580-1

25.0	DKC134-0029	Foam Core N° D2445-101 (Pour AFT Baggage Door)
------	-------------	--

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: 30558

26.0	ASSEMBLAGE	Assemblage mécanique
------	------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Assembler le DKC134-0029 selon IG 0033

Date: 3-12-10 Heure Début: _____ Heure Fin: _____ Sceau: _____



27.0	BAGGING	Faire le bagging sur la pièce
------	---------	-------------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air embiand pendant 2 heures minimum.

Date: 3-12-10 Heure Début: _____ Heure Fin: _____ Sceau: _____



Curing Début: 9:30 Curing Fin: 11:20

Date: Mercredi, 2010-11-24 10:59:56

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 30445

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

28.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-22176-1

29.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-29179-1

30.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date:

7/12/10

Heure Début:

Heure Fin:

Sceau:



31.0 LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date:

7/12/10

Heure Début:

Heure Fin:

Sceau:



32.0 BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date:

7/12/10

Heure Début:

Heure Fin:

Sceau:



Curing Début:

3:25

Curing Fin:

8:00

Date: Mercredi, 2010-11-24 10:59:56
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30445

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

33.0	DÉMOULAGE	Démoulage de la pièce
------	-----------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce selon IG 0018

Date: 5-12-10 Heure Début: Heure Fin: Sceau: 


34.0	TRIMAGE	Trimage
------	---------	---------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 9-12-10 Heure Début: Heure Fin: Sceau: 

35.0	AAC1605	Label N° D0588-041
------	---------	--------------------

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Label N° D0588-041 N° de Lot: 1-28975-1

36.0	AAC1609	Surface Veil
------	---------	--------------

Commentair Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s)
Surface Veil N° de Lot:

37.0	AAC1220	Résine Mia-Poxy 100
------	---------	---------------------

Commentair Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)
Résine Mia-Poxy 100 N° de Lot: 1-25679-1

38.0	AAC1221	Durcisseur 95 Pour Résine Mia-Poxy
------	---------	------------------------------------

Commentair Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-25679-2


39.0	ASSEMBLAGE	Assemblage mécanique
------	------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le abel N° D0588-041 selon IG 0111.

Laisser scher pendant 4 heures.

Date: 13-12-10 Heure Début: Heure Fin: Sceau: 

Date: Mercredi, 2010-11-24 10:59:56
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 30445

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

40.0 AAC1390 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.025 KIT(s)/Unit Total: 0.025 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-26644-1

41.0 AAC1617 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.02 UNITE(s)/Unit Total: 0.02 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot: _____

42.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 13-12-10 Heure Début: _____ Heure Fin: _____ Sceau:

43.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-38051-2

44.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-28362-1

45.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation et l'application du primer selon I.G. 0008

Quantité: 1 Date: 10 Dec 2010 Sceau:

Quantité: 1 Date: 11 Jan 11 Sceau:

46.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 17 Jan 11 I.V. Sceau:

47.0 EMBALLAGE Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: Mercredi, 2010-11-24 10:59:56
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30445

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 17 Jan 11 Sceau: L.B.

~~fab.~~

Job 30445

B 63464